

Date: Friday, 01/02/2008 12:45:24 PM  
User: Jean-Luc Menard

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STEM
<b>Job Number</b> :	37145		
<b>Estimate Number</b> :	11107		
<b>P.O. Number</b> :		<b>Part Number</b> :	D34071
<b>This Issue</b> :	01/02/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3407 REV C
<b>First Issue</b> :	11	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	35364	<b>Drawing Revision</b> :	C
<b>Written By</b> :	<i>JLM 08.02.01</i>	<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	08/02/2008
<b>Comment</b> :	Est Rev:A 05.10.18 New issue KJ/EC		

**Qty:** 32 **Um:** Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M174R0750	Inventory
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P. 4500



(32)

**Comment:** Qty.: ~~0.3843~~ (ts)/Unit Total : ~~11.5200~~ (ts) 14.85

Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)

Batch: M105710

Y.A

08/02/02

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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(32)

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA596 Rev: AA &amp; Dwg D3407 Rev: C

2-Deburr

Y.A / SE

08/02/02

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(32)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Y.A / SE

08/02/02

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

JLM 08/02/08

(32)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(32)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JLM 08/02/08

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 37145

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*C. M. / 02.02.08*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PAT D.*

*AS 08/02/08 (32)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(32)*  
*2008/02/12*

Job Completion



*min 2008/2/11*

*(32)*

*U*

DART AEROSPACE LTD		Work Order: 37145
Description: TOW RING		Part Number: D3407-1
Inspection Dwg: D3407 Rev: C		Page 1 of 1

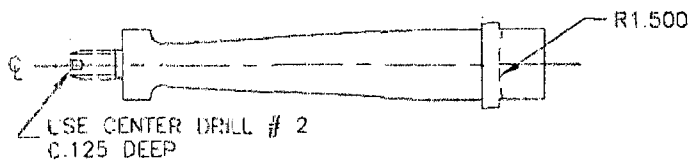
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	+/- 0.010	5.270	✓			
4.250	+0.000/-0.010	4.243	✓			
3.250	+/- 0.010	3.257	✓			
0.500	+/- 0.010	0.501	✓			
0.500 REF	+/- 0.010	0.491	✓			
0.470	+/- 0.010	0.476	✓			
Ø 0.625	+/- 0.010	Ø 0.624	✓			
Ø 0.750	+/- 0.010	Ø 0.749	✓			
Ø 0.625	+/- 0.010	Ø 0.624	✓			
Ø 0.363	+/- 0.010	Ø 0.362	✓			
0.063 REF	+/- 0.010	0.067	✓			
R 0.020	+/- 0.010	R 0.020	✓			
0.550	+/- 0.010	0.547	✓			
0.625	+/- .010	0.628	—			milling
0.250	0.010/0.000	0.250	—			milling
0.150	+/- .010	0.150	—			milling
MOW=0.266	+/- 0.001	0.265	✓			

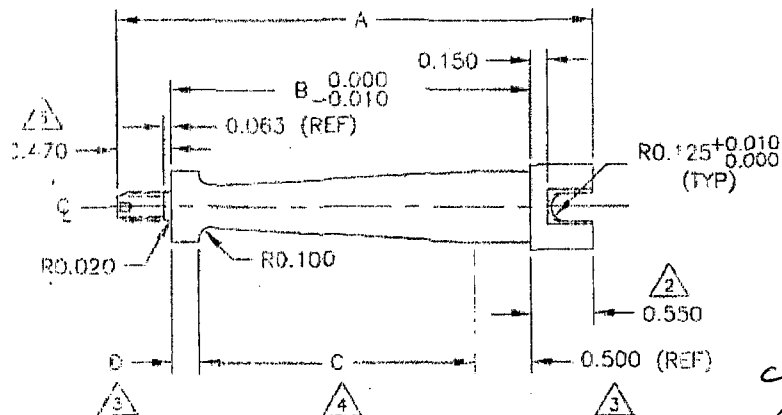
Measured by: BA/	Audited by: [Signature]	Prototype Approval:
Date: 08/02/02	Date: 08-02-02	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



RELEASED

05 09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

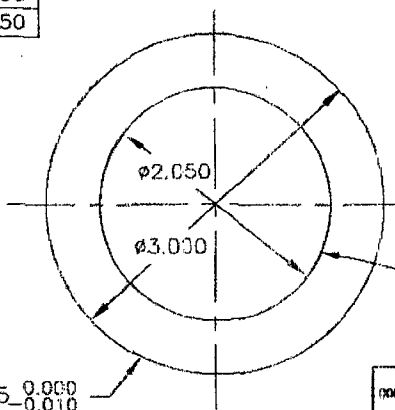
D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) Ø0.750 O.D.
- 3) Ø0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM Ø0.355 O.D. TO Ø0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

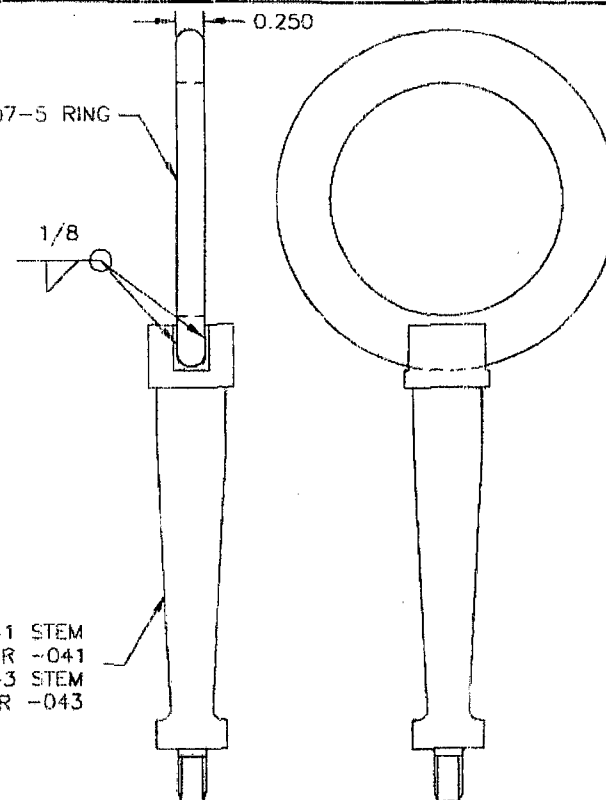
### D3407-5 RING:

- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING

USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043



### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.08.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	43	APPROVED
DATE	05.09.09	TOW RING

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DART AEROSPACE USA, INC.  
PORT HANCOCK, VA

DRAWING NO. D3407

SHEET 1 OF 1

SCALE

1:1